

Date: Monday, 2/11/2008 11:37:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 37310	
Estimate Number : 12966	
P.O. Number :	Part Number : D3637041
This Issue : 2/11/2008 S.O. No. :	Drawing Number : D3637 UNDER REVIEW <i>Rev B</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : <i>Rev B</i> <i>10/8/2011</i>
Previous Run : 34537	Material :
Written By :	Due Date : 2/27/2008 Qty: 20 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS .080
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Comment: Qty.: 0.0945 sf(s)/Unit Total : 1.8900 sf(s)

304SS .080

Batch: *IB 8-2-14 101873*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3637

Dwg Rev: *A* *IB 8-2-14*Prog Rev: *A*2-Deburr if necessary *IB 8-2-14*

(54)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*IB 8-2-14*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/02/14 (224) cuts

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3637






SB 08/04/10

(19)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3637-041 PAR #: N/A Fault Category: Prod/Asst. Prod # Small NCR: ☒ Yes No DQA: D Date: 08/04/10
(D350-744) QA: N/C Closed: D Date: 08/04/10

NCR: 37310		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/10	5	4 piece were swaps did for like rev A Added to the 1 piece is swaps hold in it	 08.04.10	Scrap & destroy No replace	 08/04/10	 08/04/10	 08.04.10	 08/04/10

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 11:37:52 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37310

Part Number: D3637041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21059L4

Nutplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~20.0000~~ Each(s)

Nutplate

BATCH: M106322

19.000

FF 08-04-10

(19)

7.0

MS20426AD33

Rivet

Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~40.0000~~ Each(s)

Rivet

BATCH: M1563

38.000

FF 08-04-10

(19)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'Sink as per Dwg D3637

2-Install Nut plate as per Dwg D3637

E 08/04/10

FF 08-04-10

(19)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 08/04/10 X19

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST261

A2 08/04/11

(19)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/11

Job Completion



mf 08-04-11

W

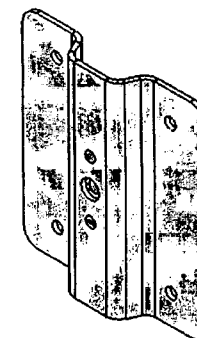
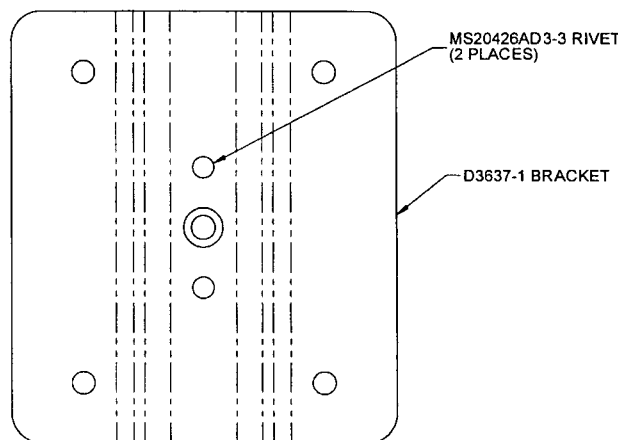
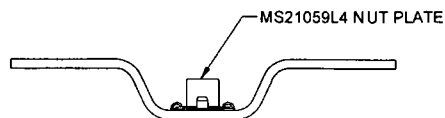
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

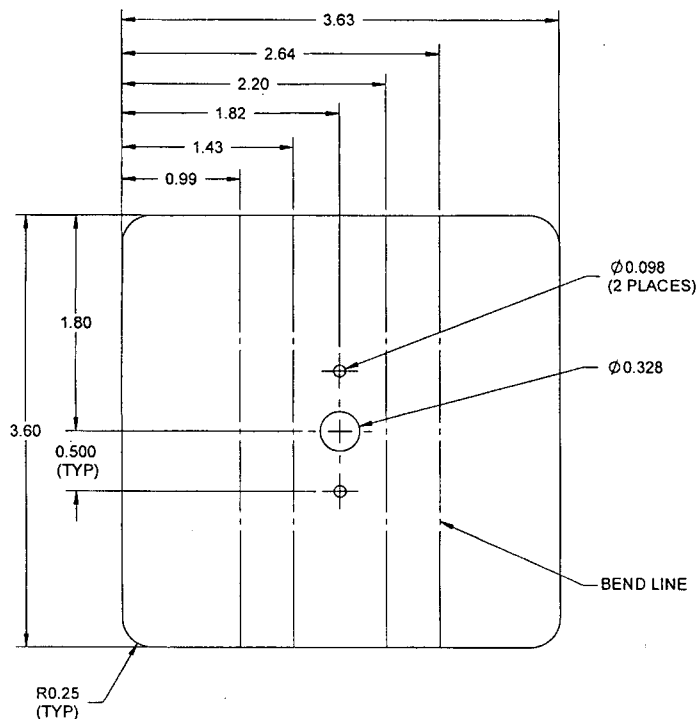
QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

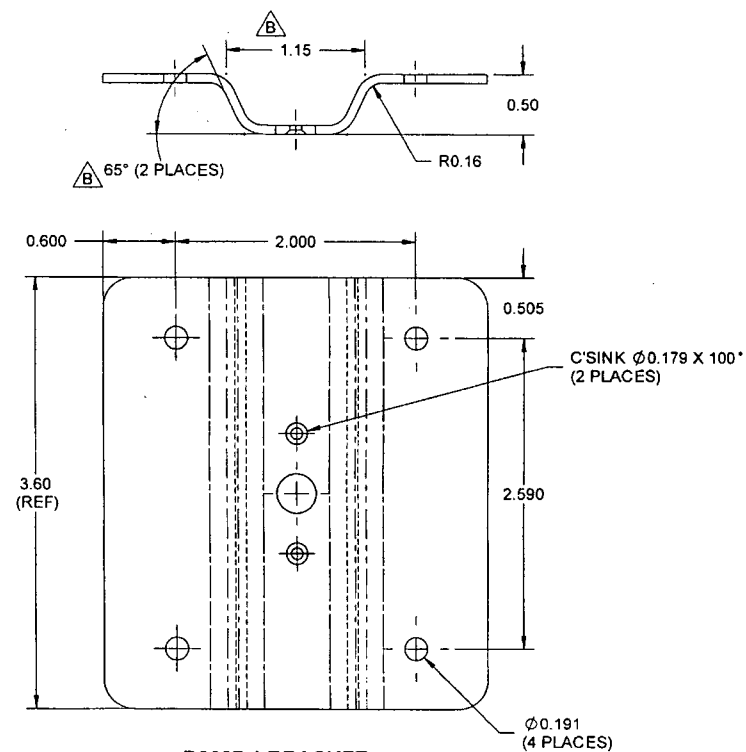
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

NO. 31310
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

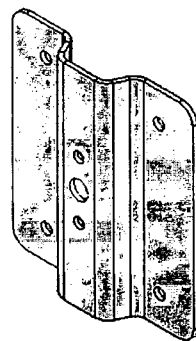
B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	FE	DRAWING NO.	REV. B
MFG. APPR.	FE	D3637	SHEET 1 OF 3
APPROVED	FE	TITLE	SCALE
DE APPR.	FE	BRACKET	1:
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D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



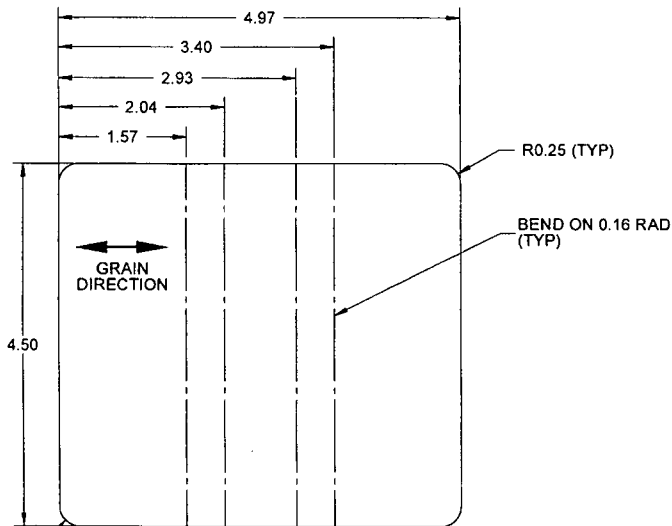
D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

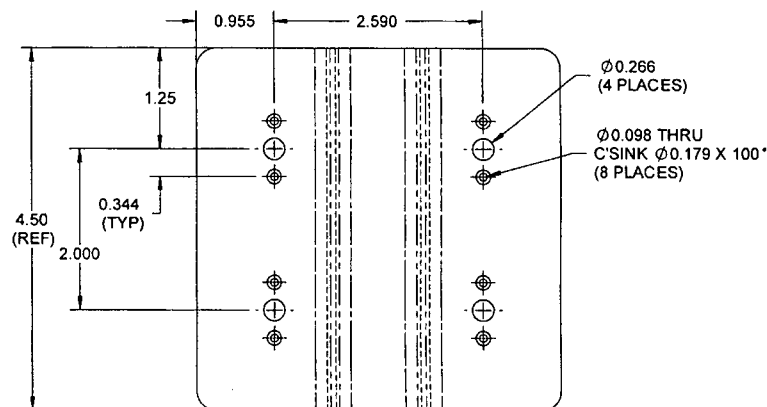
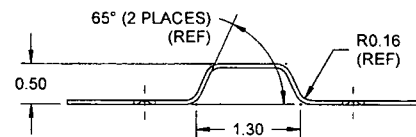
NO. 22310
WORK ORDER
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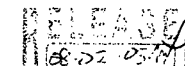
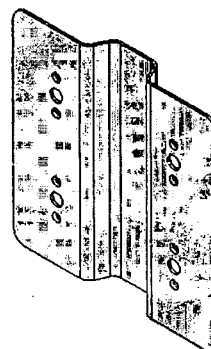
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DRAWN	LE	DRAWING NO.	REV. B
CHECKED	RE	D3637	SHEET 2 OF 3
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APPROVED	JW	BRACKET	1:1
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DATE	07.12.18		



D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

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WORK ORDER
NO. 39310

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CHECKED	PH	DRAWING NO.	REV. B
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APPROVED	MD	TITLE	SCALE
DE APPR.	MD	BRACKET	2:3
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L Lacelle

From: Leanne Elsliger [lelsiger@dartaero.com]
Sent: February 14, 2008 8:56 AM
To: 'L Lacelle'
Subject: RE: D3637-041

Yes, this will be fine.

When the first one has been bent, please call me for an inspection...but go ahead and waterjet.

Leanne

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: February 13, 2008 10:54 AM
To: Leanne Elsliger; Mike Petsche
Subject: D3637-041

It's calling for 304 .080, we have .090 that actually measure .086-.088, can we use this???

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd